

Date: Monday, 07/07/2008 4:15:22 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BK117 SKIDTUBE ASSEMBLY
Job Number : 40332	
Estimate Number : 12899	
P.O. Number :	Part Number : D117762011
This Issue : 07/07/2008 S.O. No. :	Drawing Number : N/A PRELIM <i>RE</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : A PRELIM <i>RE</i>
Previous Run : 38987	Material :
Written By :	Due Date : 18/07/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.7.07</u>	
Comment : Est Rev:A 07.06.11 New Issue EC Est Rev:B 08-02-22 change to revA DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 08.7.24

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D117-762-011 CHG001

S 08/08/25

2.0	40332A	BK117 SKIDTUBE ASSEMBLY
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**Comment:** Sub-Component BK117 SKIDTUBE ASSEMBLY1 x D117-762-041 Batch: 40332

SL

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D35121	Wearplate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARPLATE

Batch: 39020

JS 08/07/10 (X)

5.0	AN960JD10L	Washer
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**Comment:** Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M104885

JS 08/07/10 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332

Part Number: D117762011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN3C4A	BOLT
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
BOLT
BATCH: M108568 New Batch. JS 08/07/10 (X)

7.0	AN451A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
BATCH: 108077 JS 08/07/10 (X)

8.0	D2972	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bushing
BATCH: B14103 JS 08/07/10 (X)

9.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Nut
BATCH: M107478 JS 08/07/10 (X)

10.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS JS 08/08/05

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D117-762-011
Location: _____
PPP Rev: Draft JS 08/08/05 SC

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE JS 08/08/26

Job Completion



40332A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:15:58 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BK117 SKIDTUBE ASSEMBLY
Job Number :	40332A		
Estimate Number :	12898		
P.O. Number :		Part Number :	D117762041
This Issue :	07/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3582 REVA PRELIM <i>BE</i>
First Issue :	/ /	Project Number :	N/A
Previous Run :	38987A	Drawing Revision :	A PRELIM <i>BE</i>
	Type :	Material :	
	SKIDTUBES	Due Date :	18/07/2008
Written By :		Qty:	1
Checked & Approved By :	<i>JUL 08-7-07</i>	Um:	Each
Comment :	Est Rev:A 07.06.11 New Issue EC Prototype for engineering use only (LG0005-32910) Est Rev:B 08-02-22 change to revA as per dwg DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROLPhotocopy bluefile & type labels per PPP D117-762-041 CHG001 *N/A*

2.0	D2962150	3.540 Outer Tube, Extrud
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion *B28622*

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

4.0	BENDING	BENDING MACHINE-- SKIDTUBES
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**Comment:** BENDING MACHINEBend tube as per program on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A". *DP 8-7-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Cut Fwd end of the tube using DT8185 ✓
- 2-Cut Aft end at VC using DT8185 ✓
- 3-Debur ends ✓
- 4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE*** ✓
- 5-Locate DT 8973 & Drill Ground wire hole on top of Tube. ✓
- 6-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill. ✓
- 7-Drill pilot holes for wearplates using DT8974
- 8-Open wearplate holes and ground wire holes to Ø19/64" (0.297") as per Dwg D3582.
- 9-Open Aft Cap holes using .209" drill. ✓
- 10-Debur holes. ✓

DS
8-8-14

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 814/06

BE 08/07/14

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch: m08076

m107877

BE 08/07/14

2-Grind flush

11 8-7-15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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8.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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Comment: VISUAL INSPECTION OF GROUND WELDS

1080814

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

1080814

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

ALUM 8-8-14

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-8-15

12.0	D2971	Cross Bolt Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

* Cross Bolt Spacer
batch 39011 SL 8-8-18

13.0	D2973	Cross Bolt Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

* Cross Bolt Spacer
Batch: 14636 SL 8-8-18

14.0	D36621	Crossbolt Spacer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

* SPACER
batch 39585 SL 8-8-18

15.0	D36623	Crossbolt Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

* SPACER
batch 37190 SL 8-8-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D35841

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEB B 40362

Q H 7-7-15

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .750"(4Places) as per Dwg D3582, section B-B

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M107801

Exp Date: 8-10-1

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: M108026

BE 08/08/19

6-Grind welds flush

SL 8-8-19

H 7-7-15

Tools: E

18.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/08/20 (P)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (P)

20.0

POWDER COATING

POWDER COATING



M108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Pressure wash - FZ 08/08/20 (P)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320
1:35

M-F 08/08/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-21

(X) 1

22.0

ALS41032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Insert

Batch: m105819

FL

23.0

ALS4428165

Inserts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inserts

batch m6989

***same as ALS7-428-165 QSI 0017 ***

FL

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3582.

FL 08/08/21 (P)

25.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 641523

FL

26.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 638527

FL

27.0

D35089

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 640359

FL 08/08/21 (P)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D350811

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Batch: B38415

WEARPLATE

FL

29.0

D350813

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B38528

FL

30.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38613

FL

31.0

D35589

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B36420

FL

32.0

D355811

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B36419

FL

33.0

D355813

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B40400

FL

34.0

AN3C4A

BOLT



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

BOLT

Batch: M108599

FL 08/08/21 (P)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m108744

FL

36.0

AN44A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch m106918

FL

37.0

AN960C10L

washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

washer

Batch: m108618

FL

38.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch m104885

FL

39.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch m108583

FL

40.0

D3492049

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

batch B40356

FL

41.0

D3492051

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

batch B59723

FL 08/08/21 (13)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 40332A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

D3492053

Plug Assembly



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

PLUG ASSEMBLY

batch

540357

FL

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex

Batch:

M108801

Exp Date:

08/10

3-Install Wearplates as per Dwg D3582,

Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex

Batch:

M108801

Exp Date:

08/10

4- Wing Walk as per Dwg D3043 and QSI 005 4.4

M108496 - FL 08/08/22

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/25

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762-041

Location:

PPP Rev:

PPP

8/8/25

SC

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



U 08.08.26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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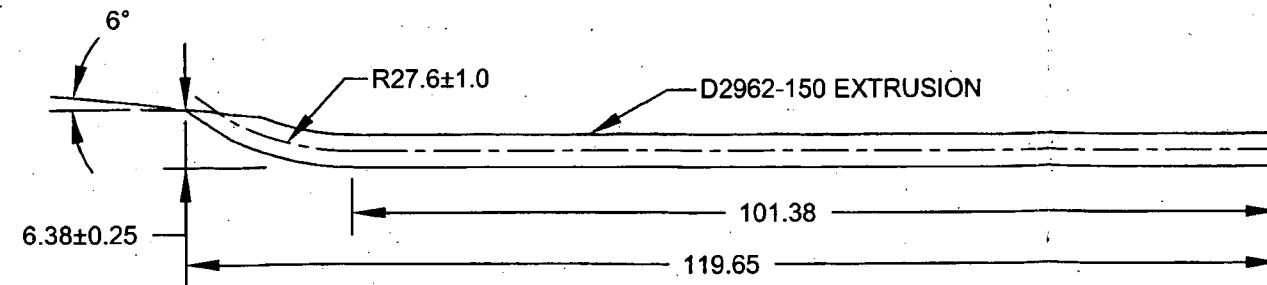
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

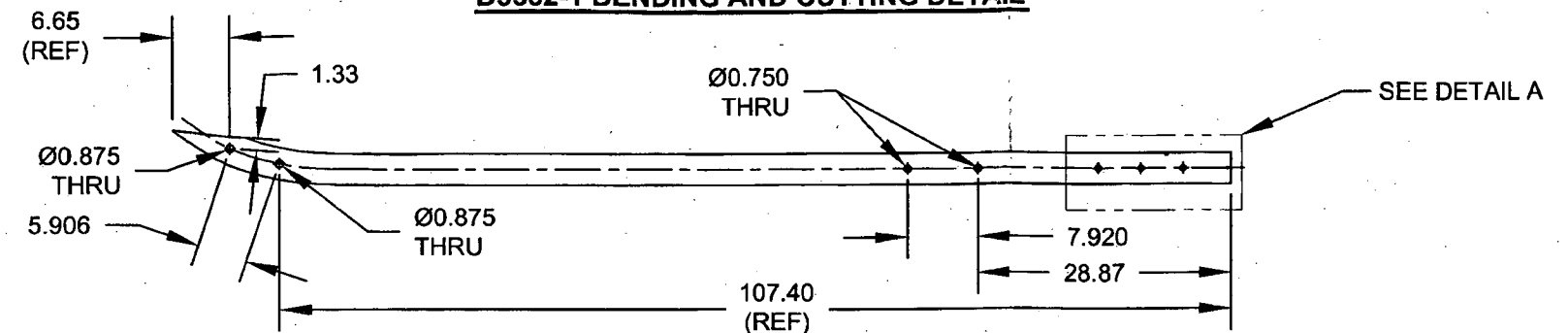
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

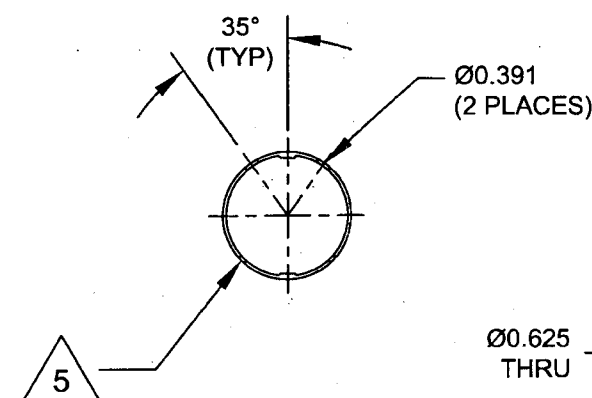
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



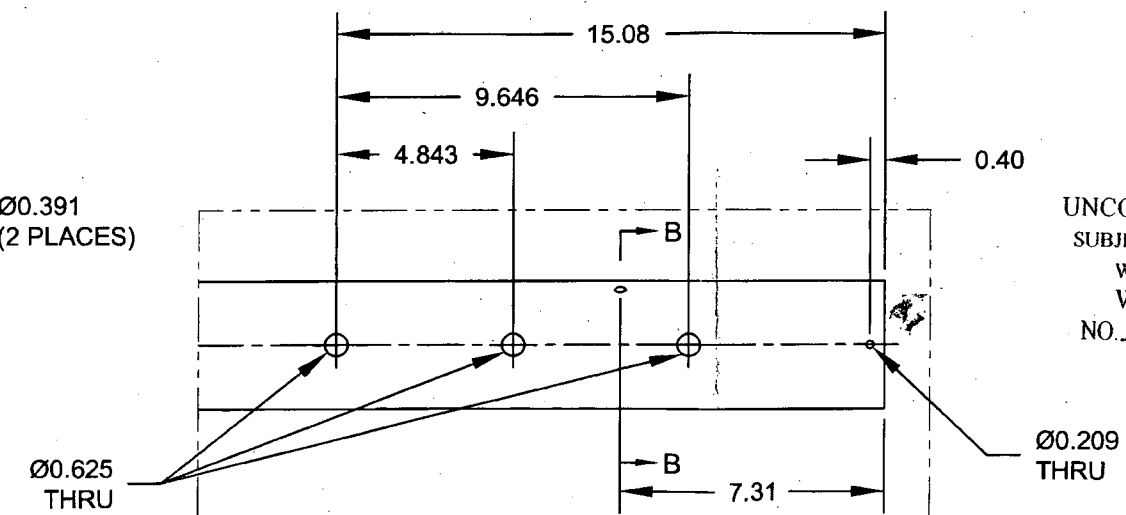
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

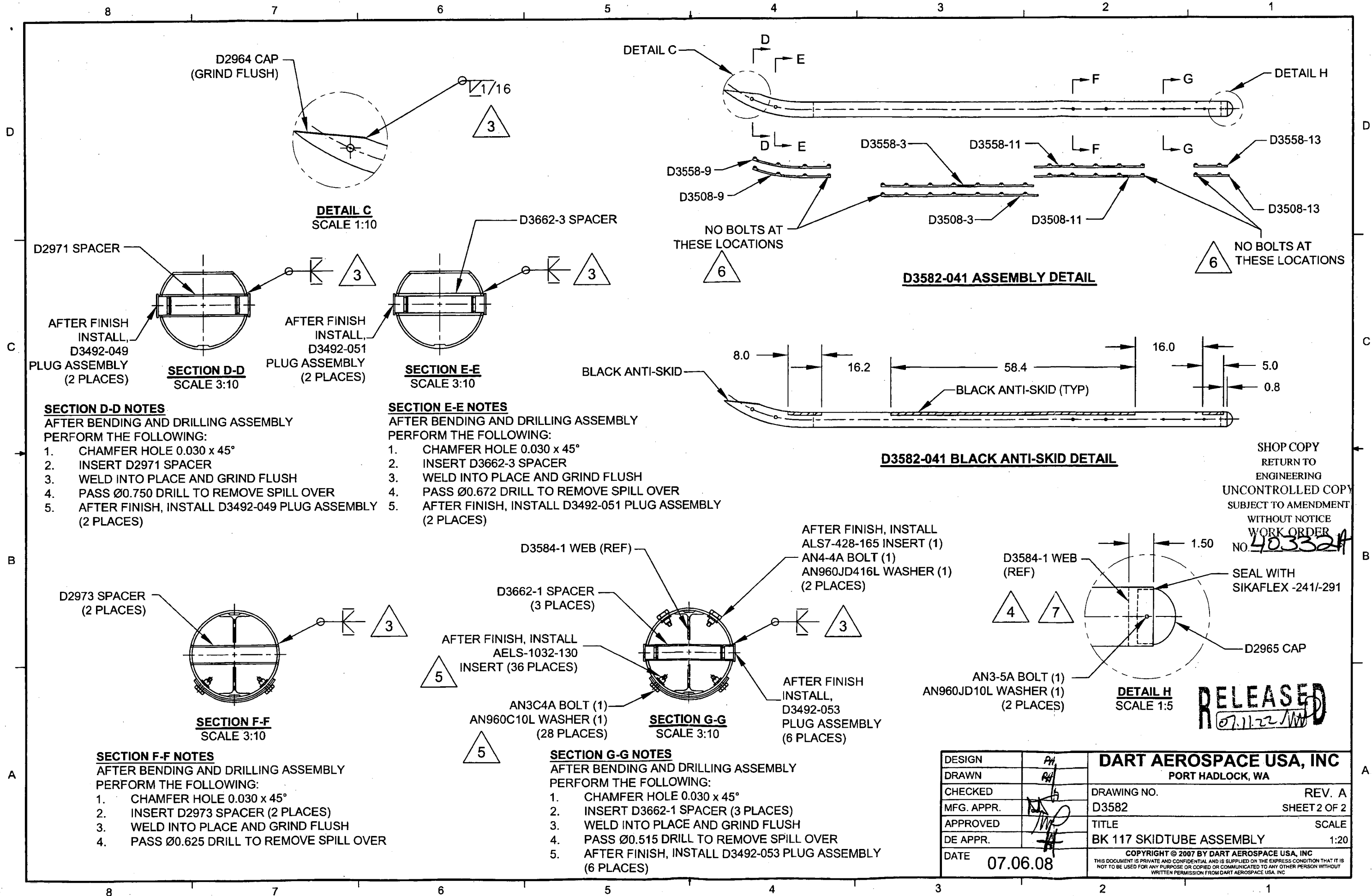


DETAIL A
SCALE 1:5

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NO. 148

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barclay Elliot
Job number: 38384A
Part number: D117 762 041
Description: Skid tube BK117
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pet Duval Date of Test Coupon 08-04-14
Welder Barclay Elliot Date of Test Coupon 08-04-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld